

Date: Tuesday, 02/06/2009 3:57:06 PM
 User: Julie Dawson

Process Sheet








Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RIB ASSY (BASKET LID, RH)
Job Number :	48334		
Estimate Number :	13664		
P.O. Number :		Part Number :	D3838042
This Issue :	02/06/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3838 REV A
First Issue :	//	Project Number :	N/A
Previous Run :	45947	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>Julie Dawson</u>	Due Date :	09/06/2009
Comment :	Est Rev:A 08-12-01 new issue DD verified by:EC		

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
		
Comment: Qty.: 1.0833 f(s)/Unit Total : 2.1666 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M111143</u>		
		<u>SAD 09-06-04</u>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1- cut D3838-2 and D3838-3 rib as per dwg D3838 2- remove identification markings 3- deburr		
		<u>SAD 09-06-04</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
		<u>SAD 09-06-04</u> (2)
4.0	D37591	Bushing
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Bushing batch: <u>B46536</u>		
		<u>PL 09-06-04</u>
✓ 5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 A/R ER316 S.S. Rod Batch: <u>M106762</u> 2- c/sink hole as per dwg 3- grind weld flush where indicated on dwg D3838		
		<u>PL 09-06-04</u> (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 02/06/2009 3:57:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 48334

Part Number: D3838042

Job Number:



Seq. #:

Machine Or Operation:

Description :

- 4- weld D3759-1 bushing as per dwg D3838
- 5- grind bushing weld flush as per dwg dwg D3838
- 6- deburr hole if necessary

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 09/06/05 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AD 09/06/05 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

AD 09.06.08 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08
MF
09-06-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

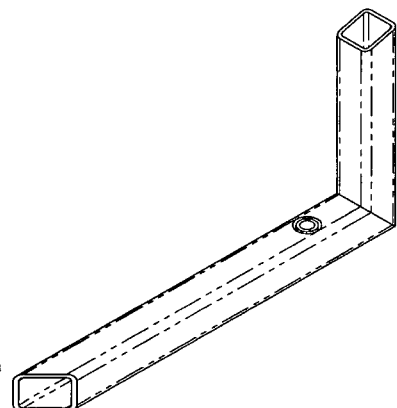
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

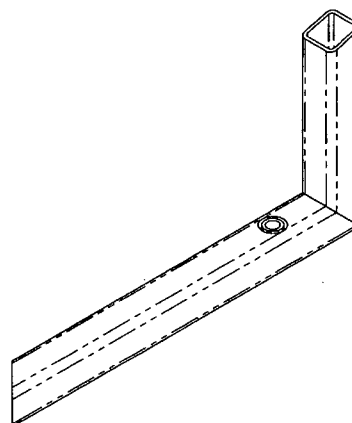
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

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08/11/08

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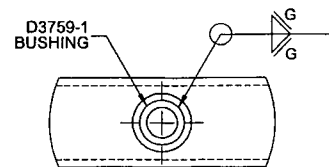
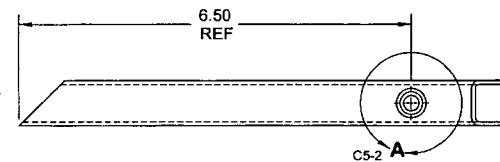
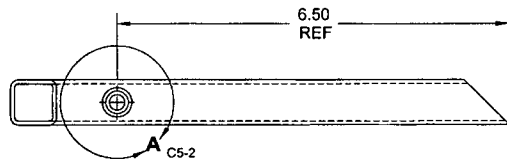
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs

REV.	NEW ISSUE	DESCRIPTION	MB	08.10.08
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.08			

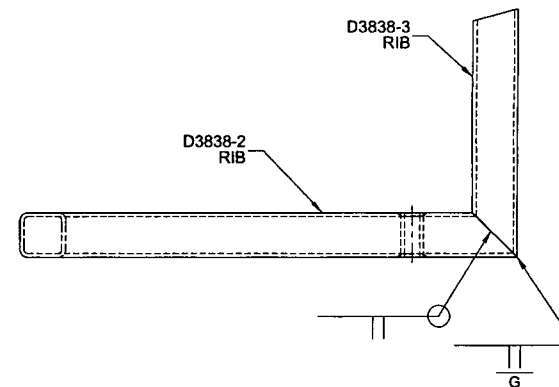
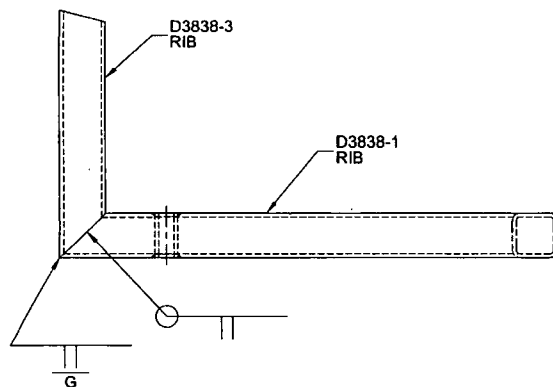
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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DETAIL A
D2-2
D7-2
SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

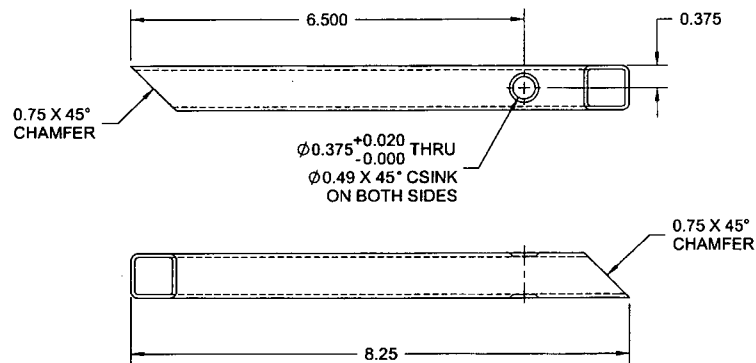
D3838-042 RIB ASSY (BASKET LID, LH)

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08/10/08

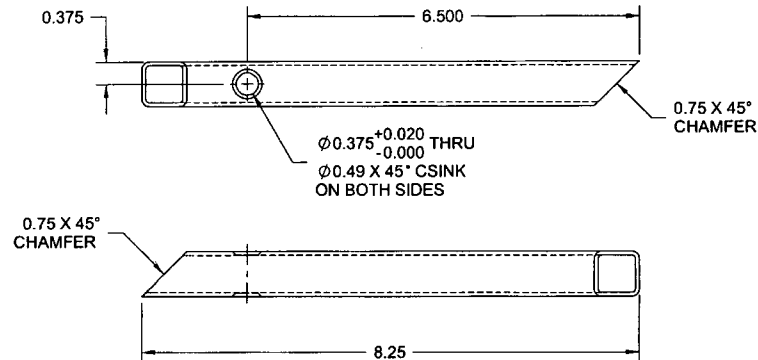
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MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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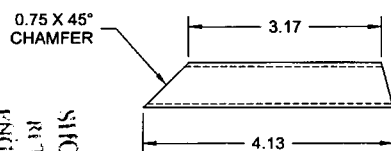
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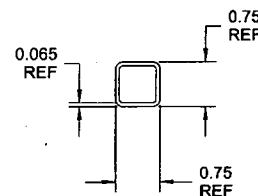
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

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NO. 18334

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

RELEASED
24/11/2011

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CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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8 7 6 5 4 3 2 1